

MODEL W1715 4" X 6" Metal Cutting Bandsaw



OWNER'S MANUAL

(FOR MODELS MANUFACTURED AFTER 2/08)

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WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT
THE WRITTEN APPROVAL OF WOODSTOCK INTERNATIONAL, INC.



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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USE THE QUICK GUIDE PAGE LABELS TO SEARCH OUT INFORMATION FAST!





INTRODUCTION

Woodstock Technical Support

This machine has been specially designed to provide many years of trouble-free service. Close attention to detail, ruggedly built parts and a rigid quality control program assure safe and reliable operation.

Woodstock International, Inc. is committed to customer satisfaction. Our intent with this manual is to include the basic information for safety, setup, operation, maintenance, and service of this product.

We stand behind our machines! In the event that questions arise about your machine, please contact Woodstock International Technical Support at (360) 734-3482 or send e-mail to: tech-support@shopfox.biz. Our knowledgeable staff will help you troubleshoot problems and process warranty claims.

If you need the latest edition of this manual, you can download it from <http://www.shopfox.biz>.
If you have comments about this manual, please contact us at:

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MACHINE SPECIFICATIONS



Phone #: (360) 734-3482 • Online Tech Support: tech-support@shopfox.biz • Web: www.shopfox.biz

MODEL W1715 4" X 6" METAL CUTTING BANDSAW

Motor

Type	TEFC Capacitor Start Induction
Horsepower	³ / ₄ HP
Voltage	110V
Phase	Single
Amps	5A
Speed	1725 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	V-Belt & Gear Drive
Bearings	Sealed and Lubricated

Main Specifications

Operation Information

Blade Speeds	78, 108, 180 FPM
Standard Blade Length	¹ / ₂ " x 0.028" x 64 ¹ / ₂ "

Cutting Capacities

Angle Cuts	0° -60°
Vise Jaw Depth	6 ¹ / ₂ "
Vise Jaw Height	3 ¹ / ₄ "
Max. Capacity Rectangle Height at 90°	4 ¹ / ₂ "
Max. Capacity Rectangle Width at 90°	6"
Max. Capacity Round at 90°	4 ¹ / ₂ "
Max. Capacity Rectangle Height at 45°	4 ¹ / ₂ "
Max. Capacity Rectangle Width at 45°	3 ¹ / ₂ "
Max. Capacity Round at 45°	3 ¹ / ₂ "
Max. Capacity Rectangle Height at 60°	4 ¹ / ₂ "
Max. Capacity Rectangle Width at 60°	5"
Max. Capacity Round at 60°	4 ¹ / ₂ "

Overall Dimensions

Weight	144 lbs.
Length	16"
Width	39"
Height	19"
Foot Print (Length/Width).....	13 ³ / ₄ " x 19 ³ / ₄ "



Construction Materials

Table	Cast Iron
Stand	Pre-Formed Steel
Body	Aluminum Cast
Wheel	Cast Iron
Base	Cast Iron
Paint	Urethane Hammertone

Shipping Dimensions

Weight	148 lbs.
Length	17 ³ / ₄ "
Width	21 ¹ / ₂ "
Height	37"

Electrical

Switch	Automatic Shut-Off
Switch Voltage	110V
Cord Length	6 ¹ / ₂ ft.
Cord Gauge	18 gauge
Recommended Breaker Size	15 amp
Plug	Yes

Other

Wheel Size	7 ³ / ₈ "
Blade Guides Upper	Ball Bearing
Blade Guides Lower	Ball Bearing

Table Information

Length	10 ¹ / ₄ "
Width	6 ³ / ₄ "
Thickness	1 ¹ / ₄ "
Floor to Table Height	33"

Features

Horizontal & Vertical Operation
 Automatic Shut-Off
³/₄ HP Motor
 Work Stop

Controls and Features

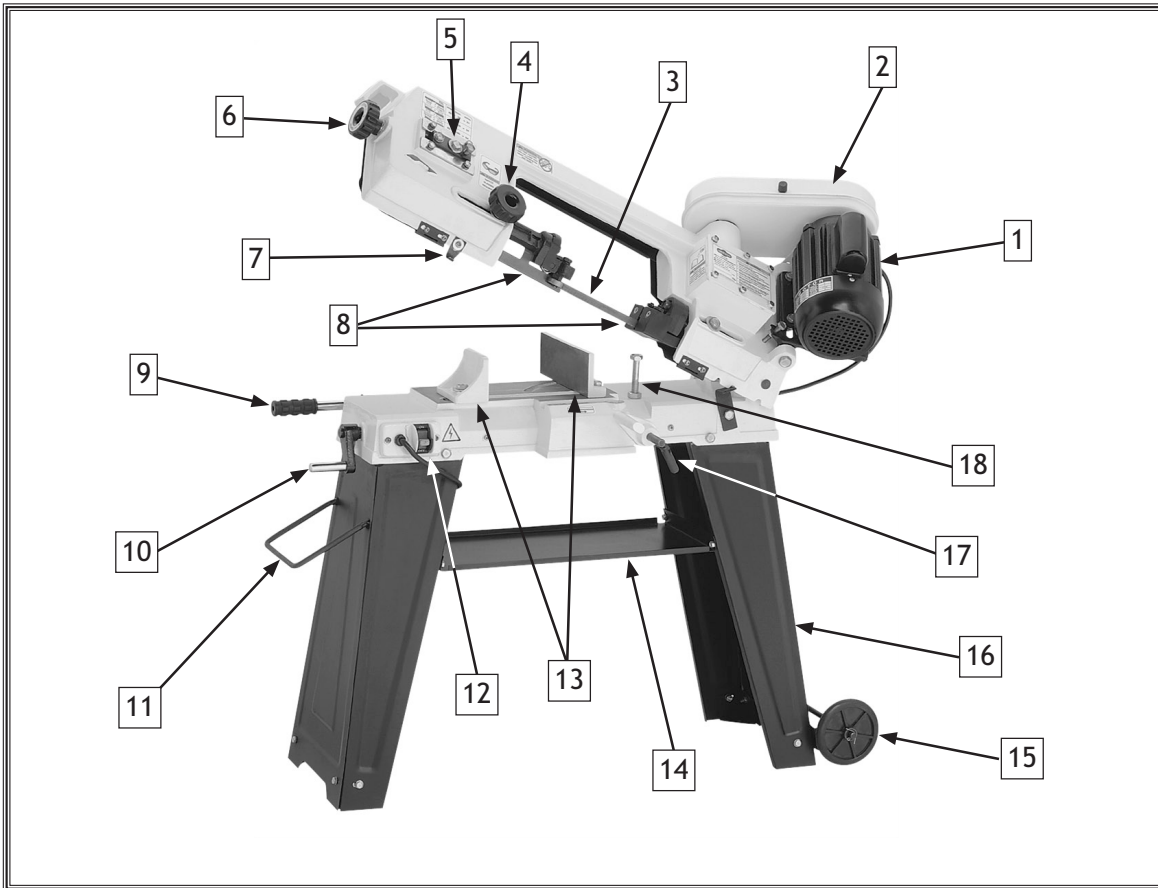


Figure 1. Machine Identification.

- | | |
|-----------------------------------|---------------------|
| 1. Motor | 10. Vise Crank |
| 2. Pulley Cover | 11. Stand Handle |
| 3. Blade | 12. Power Switch |
| 4. Adjustable Blade Guard Knob | 13. Vise Jaws |
| 5. Tilting Mechanism | 14. Tool Tray |
| 6. Blade Tension Knob | 15. Stand Wheels |
| 7. Auto Off Tab | 16. Stand |
| 8. Blade Guide Bearing Assemblies | 17. Work Stop |
| 9. Feed Adjustment Handle | 18. Horizontal Stop |

SAFETY

**READ MANUAL BEFORE OPERATING MACHINE.
FAILURE TO FOLLOW INSTRUCTIONS BELOW WILL
RESULT IN PERSONAL INJURY.**

⚠ DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

⚠ WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

⚠ CAUTION

Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment, and/or a situation that may cause damage to the machinery.


Standard Safety Instructions

1. **READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eye-glasses only have impact resistant lenses—they are **NOT** safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
5. **WEAR PROPER APPAREL.** **DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.
7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords over-heat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.

Additional Safety Instructions for Bandsaws

SAFETY



⚠️ WARNING
 READ and understand this entire manual before using this machine. Serious personal injury may occur if safety and operational information is not understood and followed. **DO NOT** risk your safety by not reading!

⚠️ CAUTION
 USE this and other machinery with caution and respect. Always consider safety first, as it applies to your individual working conditions. No list of safety guidelines can be complete—every shop environment is different. Failure to follow guidelines could result in serious personal injury, damage to equipment or poor work results.

1. **BLADE CONDITION.** A dull or damaged blade can break apart during operation, increasing the risk of operator injury. Do not operate with a dull, cracked or badly worn blade. Inspect the blade for cracks, missing teeth, and weld condition before each use.
2. **HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Hands could be crushed by machine or cut by the blade.
3. **ENTANGLEMENT HAZARDS.** Tie back loose clothing, jewelry, and long hair to prevent the operator being pulled into the moving blade.
4. **BLADE GUARD.** The blade guard is designed to minimize operator exposure to the rotating blade and pulleys to reduce the risk of serious injury. Always keep the blade guard in place during operation.
4. **BLADE REPLACEMENT.** The blade can only make a safe and efficient cut with the teeth facing the workpiece in the correct direction. When replacing blades, make sure the teeth face toward the workpiece and the pivot side of the machine. Wear gloves to protect hands and safety glasses to protect eyes.
5. **WORKPIECE HANDLING.** Always support the workpiece with the table, vise, or other support fixtures. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.
6. **LOSS OF STABILITY.** Unsupported workpieces may jeopardize machine stability and cause the machine to tip or fall, which could cause serious injury or property damage.
7. **POWER INTERRUPTION.** Unplug the machine after a power interruption. Machines without magnetic switches can start up after power is restored.
9. **HEARING PROTECTION & HAZARDS.** Noise generated by the blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals. Always wear hearing protection.
10. **HOT SURFACES.** Due to friction, the workpiece, chips, and some machine components can be hot enough to burn you.
11. **STARTING POSITION.** Never turn the saw ON with the blade resting on the workpiece to prevent blade breakage that could cause a serious injury hazard to the operator.

Avoiding Potential Injuries

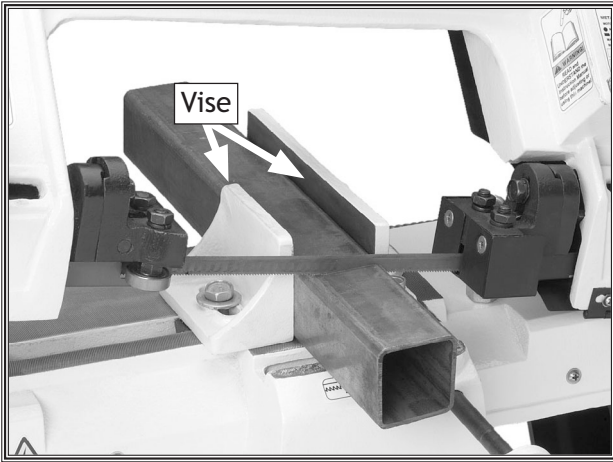


Figure 2. Always clamp workpiece in vise when cutting in the horizontal position.



Figure 4. Never cut without using the vise in the horizontal position.

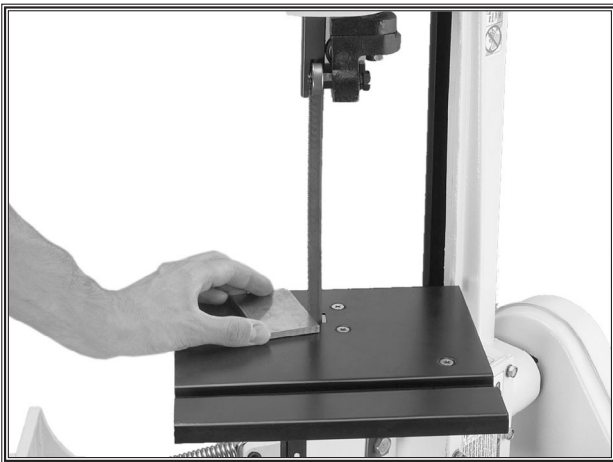


Figure 3. Always have the work table installed when cutting in the vertical position.



Figure 5. Never cut material "free-hand" in the vertical position.

SAFETY

ELECTRICAL

⚠️ WARNING

The machine must be properly set up before it is safe to operate. **DO NOT** connect this machine to the power source until instructed to do so in the "Test Run" portion of this manual.

110V Operation

The Model W1715 is wired for 110V operation. The power supply circuit used for this machine **MUST** be grounded and rated for the amperage given below. Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes.

This machine must be grounded! The electrical cord supplied with this machine comes with a grounding pin. If your outlet does not accommodate a ground pin, have it replaced by a qualified electrician.

If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, you may create a fire or circuit overload hazard—consult a qualified electrician to reduce this risk.

Extension Cords

We do not recommend using an extension cord; however, if you have no alternative, use the following guidelines:

- Use a cord rated for Standard Service (S).
- Do not use an extension cord longer than 50 feet.
- Ensure that the cord has a ground wire and pin.
- Use the gauge size listed below as a minimum.

Electrical Specifications

Operating Voltage	Amp Draw	Min. Circuit Size	Plug/Recommended Plug	Extension Cord
110V Operation	5 Amps	15A	NEMA 5-15	14 Gauge

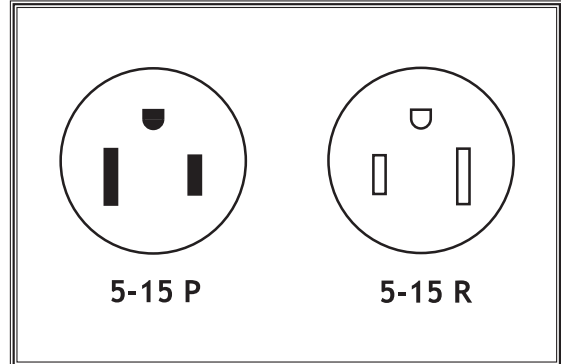


Figure 6. 5-15 plug and receptacle.

⚠️ WARNING



DO NOT work on your electrical system if you are unsure about electrical codes and wiring! Seek assistance from a qualified electrician. Ignoring this warning can cause electrocution, fire, or machine damage.

SETUP

Unpacking

This machine has been carefully packaged for safe transportation. If you notice the machine has been damaged during shipping, please contact your authorized Shop Fox dealer immediately.

Inventory

The following is a description of the main components shipped with the Model W1715. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for safer shipping.*

Inventory (Figure 7)	Qty
A. Bandsaw (not shown)	1
B. Stand Legs	2
C. Tool Tray	1
D. Corner Support Braces	4
E. Wheels	2
F. Axle	1
G. Wheel Mounting Bracket	1
H. Work Stop Rod	1
I. Work Stop	1
J. Transport Handle	1
K. Pulley Cover	1
L. V-Belt	1
M. Pulleys with Keys	2
N. Table	1
O. Table Support	1

Hardware Bag (not shown)

- Hex Wrench 4mm (Work Stop)1
- Hex Bolts M8-1.25 x 25 (Saw to Stand)6
- Hex Nuts M8-1.25 (Saw to Stand)6
- Flat Washers 8mm (Saw to Stand)6
- Hex Bolts M6-1 x 12 (Stand)8
- Phillips Head Screws M6-1 x 12 (Tray)4
- Hex Nuts M6-1 (Stand, Tray, Table) 13
- Flat Washers 6mm (Stand, Tray) 12
- Fender Washer 6mm (Table)1
- Flat Head Screw M6-1 x 12 (Table)1
- Cotter Pins (Axle & Handle)4

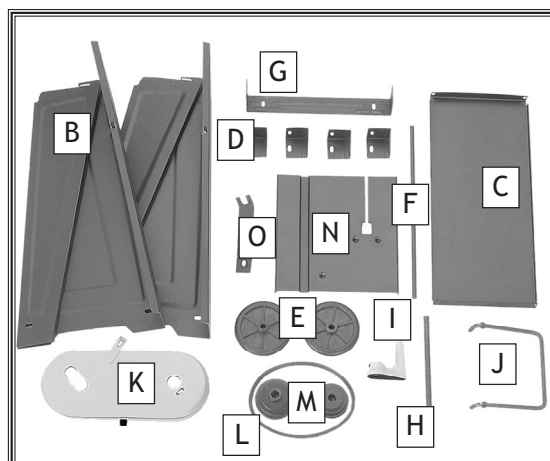
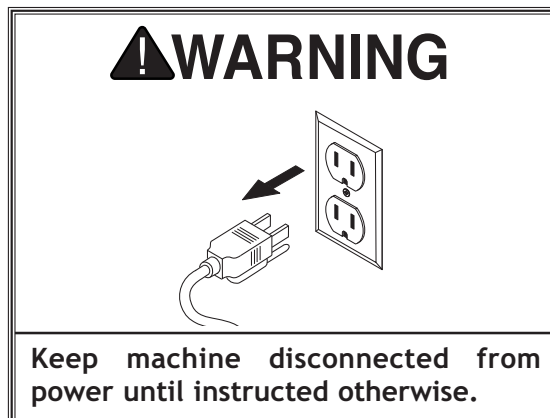


Figure 7. The loose parts shipped with the bandsaw.

SETUP

Machine Placement

- **Floor Load:** This machine distributes a heavy load in a small footprint. Some residential floors may require additional bracing to support both machine and operator.
- **Working Clearances:** Consider existing and anticipated needs, size of material to be processed through the machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your Machine Type.
- **Lighting:** Lighting should be bright enough to eliminate shadow and prevent eye strain.
- **Electrical:** Electrical circuits must be dedicated or large enough to handle amperage requirements. Outlets must be located near each machine, so power or extension cords are clear of high-traffic areas. Follow local electrical codes for proper installation of new lighting, outlets, or circuits.

Cleaning Machine

The table and other unpainted parts of your bandsaw are coated with a waxy grease that protects them from corrosion during shipment. Clean this grease off with a solvent cleaner or citrus-based degreaser. DO NOT use chlorine-based solvents such as brake parts cleaner or acetone—if you happen to splash some onto a painted surface, you will ruin the finish.

	<p>⚠ WARNING NEVER clean with gasoline or other petroleum-based solvents. Most have low flash points, which make them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur if this warning is ignored!</p>
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	<p>⚠ WARNING USE helpers or power lifting equipment to lift this Machine Name. Otherwise, serious personal injury may occur.</p>
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	<p>⚠ CAUTION MAKE your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. NEVER allow untrained visitors in your shop when assembling, adjusting or operating equipment.</p>
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	<p>⚠ CAUTION ALWAYS work in well-ventilated areas far from possible ignition sources when using solvents to clean machinery. Many solvents are toxic when inhaled or ingested. Use care when disposing of waste rags and towels to be sure they DO NOT create fire or environmental hazards.</p>

Assembly

Although the main components of the SHOP FOX® W1715 are assembled at the factory, some assembly is required. The following series of instructions are the recommended sequence best suited for the machine assembly.

Tools Needed	Qty
Safety Glasses	1 Per Person
Wrench 12mm	1
Wrench 14mm	1
Additional Person (for lifting).....	1
Sawhorses	2
Pliers.....	1
Phillips Screwdriver #2.....	1
Straightedge 12" Minimum.....	1

To assemble the bandsaw, do these steps:

1. Unfold the two stand leg assemblies. They are hinged on the edges for easy setup.
2. Use the M6-1 x 12 hex bolts, M6-1 hex nuts, and 6mm flat washers to install the corner support braces in the bottom corners of the leg assemblies (**Figure 8**).
3. On one of the leg assemblies, attach the wheel mounting bracket along with the corner support braces to the outside bottom edge, as shown in **Figure 8**.
4. Slide the axle through the holes in the wheel mounting bracket.
5. Slide the wheels onto the axle on the outside of the mounting brackets, and secure them with the cotter pins, as shown in **Figure 9**.

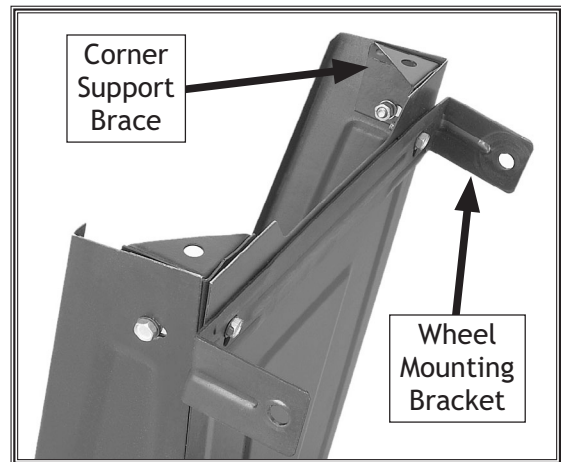
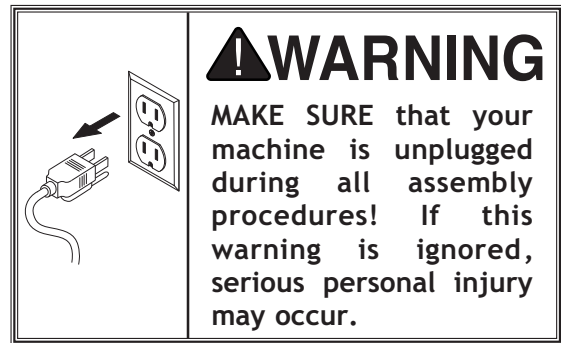


Figure 8. Corner support brace and wheel mounting bracket.

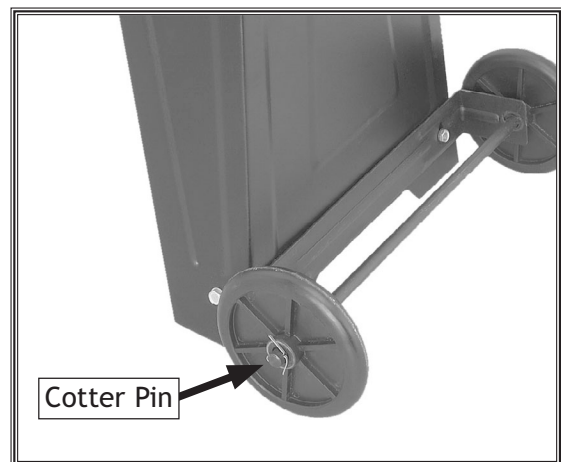


Figure 9. Wheel installed with cotter pin.

SETUP

- On the other leg, insert the handle into the pre-drilled holes and secure it with the cotter pins (see Figure 10).

	<p>⚠ WARNING The bandsaw is a heavy machine (144 lbs.) Use assistance and safe lifting/moving methods when lifting this machine.</p>
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- With the help of an assistant, lift the bandsaw onto a pair of closely spaced sawhorses or other suitable support (see Figure 11).
- Attach the legs to the bandsaw with the M8-1.25 x 25 hex bolts, 8mm flat washers, and M8-1.25 hex nuts. Tighten them with a 14mm wrench or socket just enough to secure the parts. Final tightening will take place when the stand is fully assembled.
- Remove the machine from the sawhorses, then install the tool tray in the middle of the stand with the M6-1 x 12 Phillips head screws, 6mm flat washers and M6-1 hex nuts, as shown in Figure 12.
- Check to see if the bandsaw is relatively level, then final tighten all the nuts.

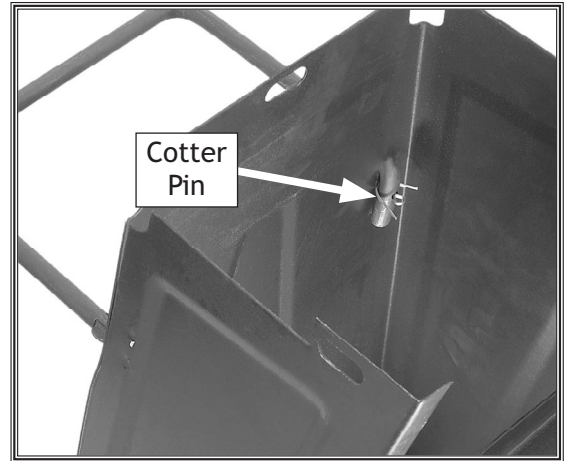


Figure 10. Handle installed with cotter pins.



Figure 11. Attaching leg assemblies.

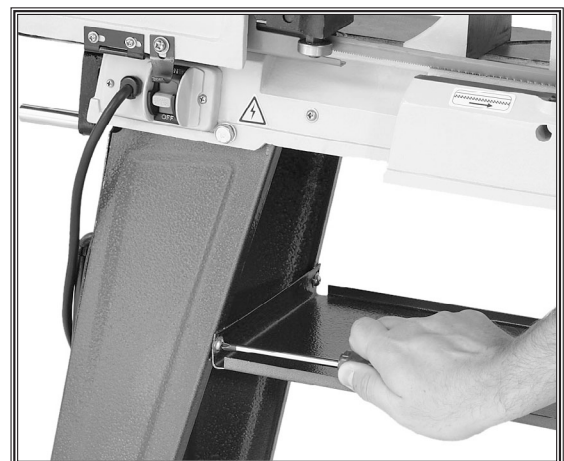


Figure 12. Installing tool tray.

SETUP

11. Place the pulley cover over the motor and gear shafts, and secure it with the pre-installed M6-1 x 12 Phillips head screws and 12mm flat washers, as shown in **Figure 13**.
12. Open the pulley cover, then insert the keys into the slots on the pulley shafts.
13. Slide the large diameter motor pulley onto the motor shaft (see **Figure 14**).
14. Install the worm gear pulley with the small diameter wheel on the shaft closest to the gear box.
15. Use a straightedge to check the alignment of the pulley wheels, as shown in **Figure 15**, and adjust them as needed.
16. When the pulley wheels are aligned, tighten the set screws on both pulleys.



Figure 13. Installing the pulley cover.

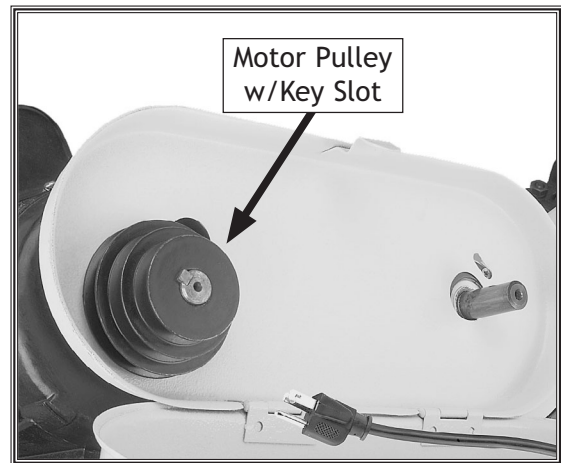


Figure 14. Motor pulley installed.

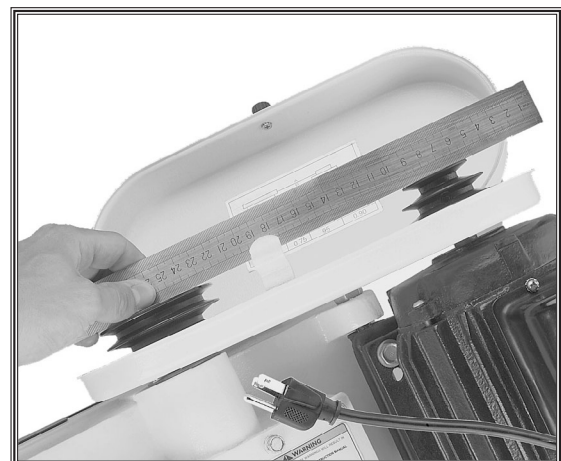


Figure 15. Checking the pulley alignment.

SETUP

17. Unthread the V-belt tension hex bolt, then pivot the motor up and slide the V-belt into the pulley grooves, as shown in **Figure 16**.
18. Release the motor, letting its weight tension the V-belt, then thread the V-belt tension hex bolt against the side of the bandsaw.
19. Install the work stop shaft into the side of the bandsaw then lock it in place by tightening the set screw, as shown in **Figure 17**.
20. Slide the work stop onto the end of the shaft and lock it into position with the locking lever, as shown in **Figure 18**.

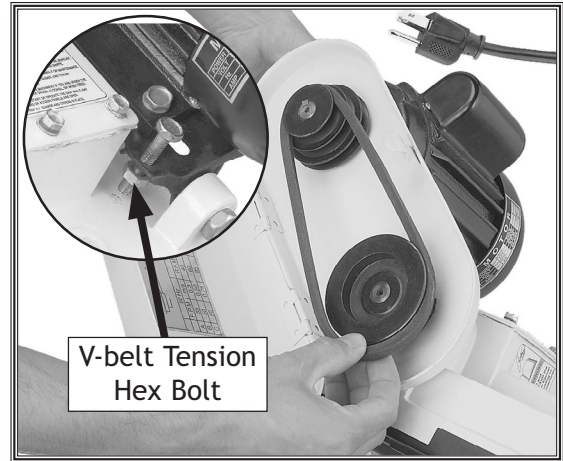


Figure 16. Installing the V-belt.



Figure 17. Installing the work stop shaft.

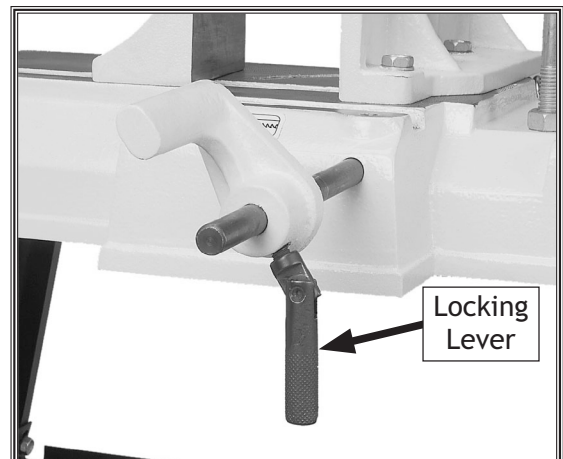


Figure 18. Work stop locking lever installed.

Test Run

Once the assembly is complete, test run the machine to make sure it runs properly for regular operations.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the safety disabling mechanism on the switch works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 37**. If you still cannot remedy a problem, contact our Tech Support at (360) 734-3482 for assistance.

To test run the machine, do these steps:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Connect the bandsaw to power.
4. Put on safety glasses and secure loose clothing or long hair.
5. Raise the bandsaw by the handle.
6. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run (**Figure 19**). The bandsaw should run smoothly with little or no vibration.
 - If you suspect any problems, immediately stop the bandsaw and correct before continuing.



Figure 19. ON/OFF switch.

OPERATIONS

General

This machine will perform many types of operations that are beyond the scope of this manual. Many of these operations can be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. **If at any time you are experiencing difficulties performing any operation, stop using the machine!**

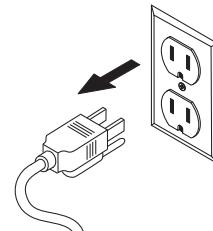
If you are an inexperienced operator, we strongly recommend that you read books or trade articles, or seek training from an experienced metal cutting bandsaw operator before performing any unfamiliar operations. **Above all, your safety should come first!**

WARNING



READ and understand this entire instruction manual before using this machine. Serious personal injury may occur if safety and operational information is not understood and followed. **DO NOT** risk your safety by not reading!

WARNING



DO NOT investigate problems or adjust the machine while it is running. Wait until the machine is turned **OFF**, unplugged and all working parts have come to a complete stop before proceeding!

WARNING



Always wear safety glasses when operating this machine. Failure to comply may result in serious personal injury.

Operation Tips

The following tips will help you safely and effectively operate your bandsaw and help you get the maximum life out of your saw blades.

Horizontal Cutting

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length (see **Figure 20**).
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Allow the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece (see **Figure 21**).
- Chips should be curled and silvery. If the chips are thin and powder like, increase your feed rate (refer to the **Metal Chip Inspection Chart** on **Page 27**).
- If the chips are burned, reduce the blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!

Vertical Cutting

- Workpieces that cannot be properly supported or stabilized without a vise should not be cut in the vertical position. Examples are chains, cables, round or oblong-shaped workpieces, workpieces with internal or built-in moving or rotating parts, etc.
- Make sure that the vertical table assembly is securely fastened to the bandsaw frame so it will adequately support the workpiece.
- Always keep your fingers away from the blade and always hold the workpiece securely in your hand (**Figure 22**).
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.

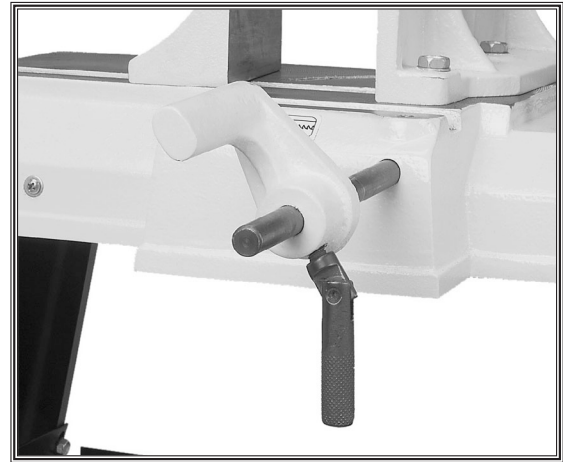


Figure 20. Work stop and lever.

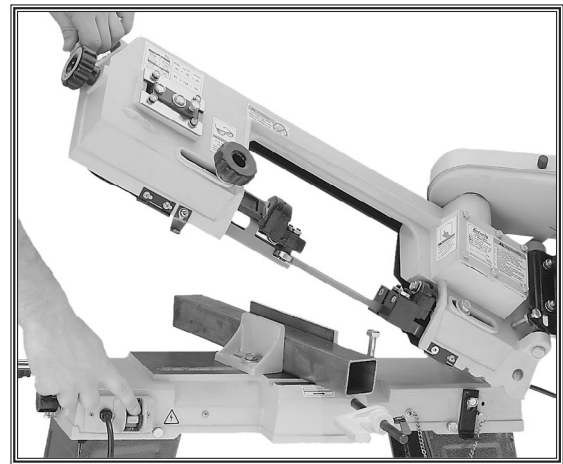


Figure 21. Proper bandsaw horizontal starting position.

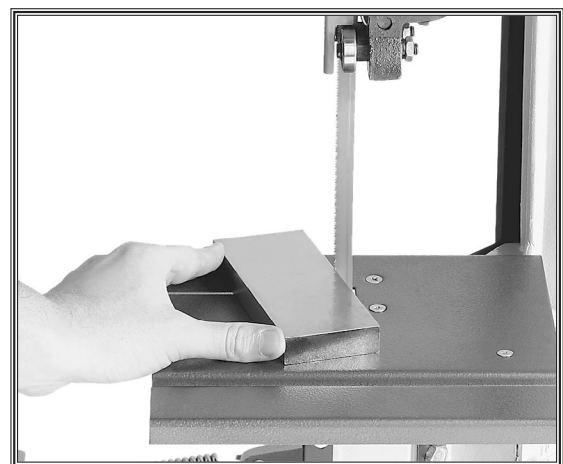


Figure 22. Proper bandsaw vertical starting position.

NOTICE

Release the blade tension at the end of the day to prolong blade life.

Vertical Operation

The Model W1715 can easily be set up for vertical cutting operations to make cuts that are not a straight cut through the entire workpiece, such as curves or pattern cuts.

To assemble the bandsaw for vertical cutting, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the two flat head screws and the blade guide cover shown in **Figure 23**.
3. Install the table and replace the two screws removed in **Step 2**.
4. Install the table bracket with the pre-installed hex bolt, the M6-1 x 12 flat head screw, and the M6-1 hex nut, as shown in **Figure 24**.
5. Place a level on the table, as shown in **Figure 25**, then use the adjustment bolt shown in **Figure 26** to make the table level.

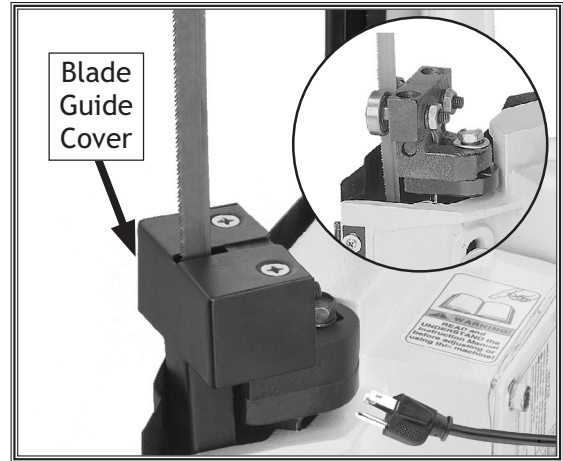


Figure 23. Blade guide cover.

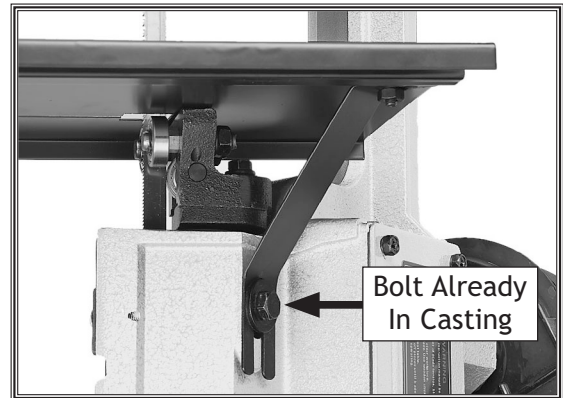


Figure 24. Table and table bracket installed.

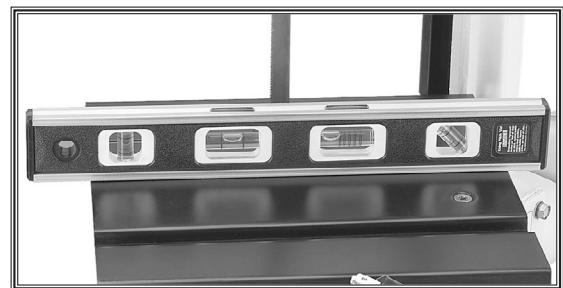


Figure 25. Adjusting table with a level.

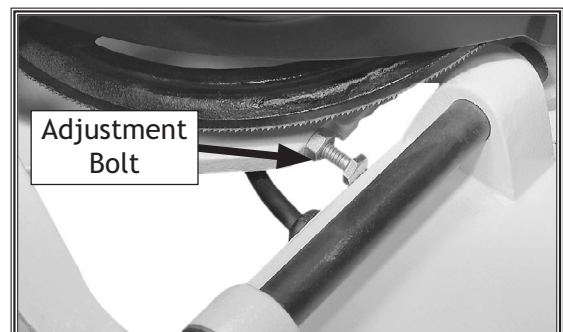


Figure 26. Table adjustment bolt.

6. Install the safety bracket and lock it in place with the pin shown in **Figure 27** to keep the saw from falling.

Note: To ensure the safety bracket fits securely in the notch on the body frame, the safety bracket may need to be slightly "modified" with a hammer or other appropriate implement to fit securely.

Head Locking Pin

CAUTION

The head locking pin secures the head in the down, horizontal position. You **MUST** secure the head with the locking pin before moving the machine to prevent the head unexpectedly springing up, causing the machine to tip or fall. Otherwise, serious personal injury or property damage could occur.

The head locking pin safely secures the head in the down position. To ensure the head does not unexpectedly spring up and tip the bandsaw over, this locking pin must be properly inserted when the bandsaw is not in use or before moving it.

To use the head locking pin, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Fully lower the head down, then insert the locking pin through the holes in the head pivot arm and base, as shown in **Figure 28**.
3. Before connecting the machine to power, remove the locking pin.

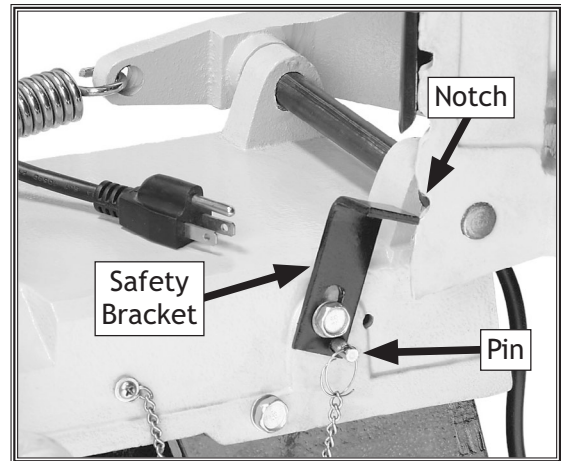


Figure 27. Safety bracket in position.

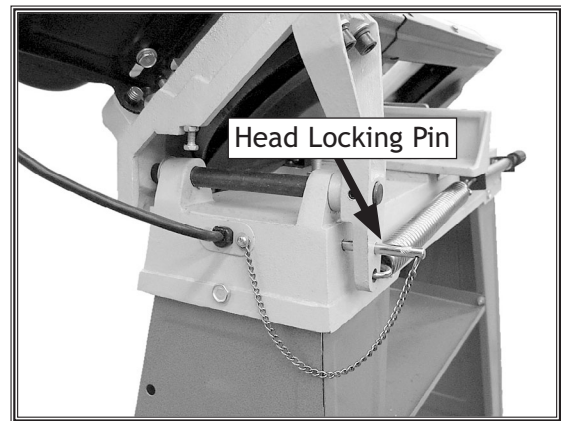


Figure 28. Head locking pin correctly installed.

Using the Vise

The vise is designed to secure the workpiece during horizontal cutting operations. Always use the vise when cutting with the bandsaw in the horizontal position.

Tools Needed	Qty
Machinist's Square	1

To use the vise on your bandsaw, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Check the vise with a machinist's square to make sure the vise is perpendicular to the blade and reads 0° on the scale as shown in Figure 29.
3. When the vise is square to the blade, place the material to be cut between the vise jaws.
4. Turn the vise crank handle (Figure 30) clockwise to firmly secure the workpiece in the vise jaws. The workpiece is now ready to cut.

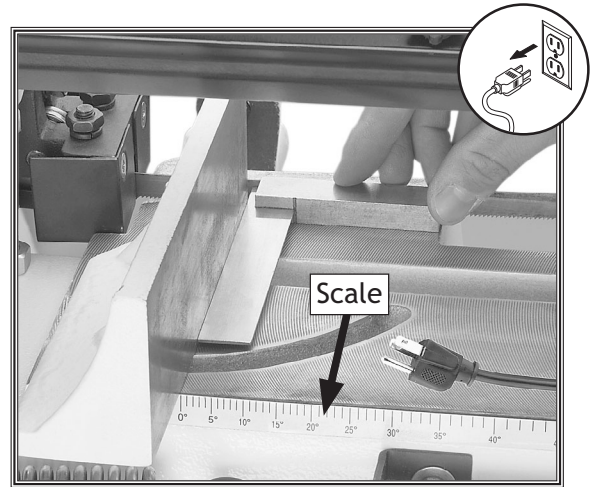


Figure 29. Using a machinist's square to adjust the vise perpendicular to the blade.

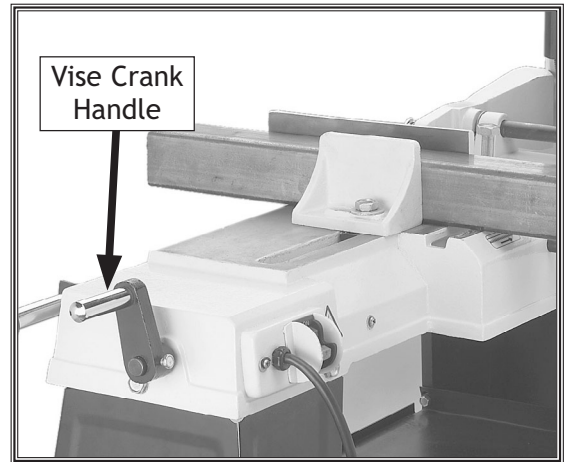


Figure 30. Vise crank handle.

Clamping Angles

The vise can hold workpieces for angle cuts ranging from 0° to 60°.

Tools Needed	Qty
Wrench or Socket 14mm	1

To adjust the vise for angle cuts, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the hex bolts on the stationary vise jaw, as shown in Figure 31.
3. Rotate the sliding edge of the vise to the desired angle, indicated by the scale, and secure the bolts.
4. Place the workpiece between the jaws and clamp firmly.

Note: The vise jaw on the lead screw pivots freely to match the angle of the other jaw.

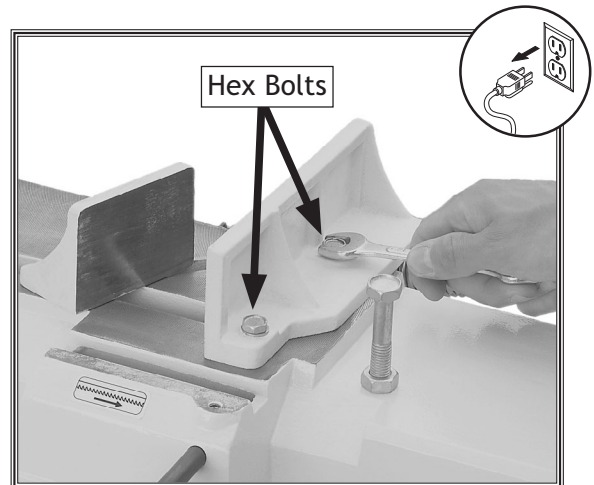


Figure 31. Loosening vise hex bolts.

Blade Guides

The blade guides should be as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust the blade guides, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the adjustment knob shown in **Figure 32** and slide the blade guide as close to the workpiece as possible, then re-tighten the knob.

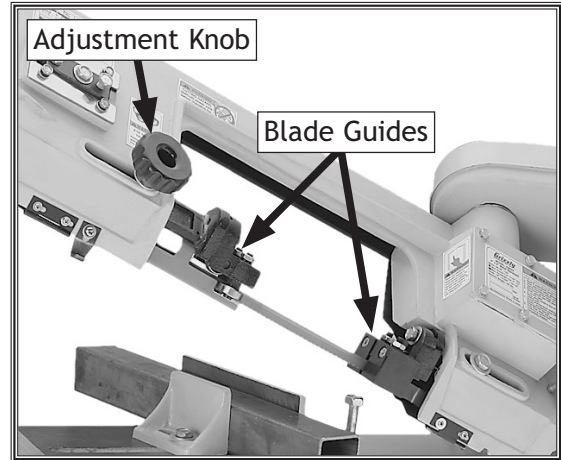


Figure 32. Blade guide adjustment knob.

Feed Rate

The feed rate is controlled by the spring and handle shown in **Figure 33**.

For Slower Feed Rate: Twist the handle clockwise to add tension to the spring.

For Faster Feed Rate: Twist the handle counterclockwise to remove tension from the spring.

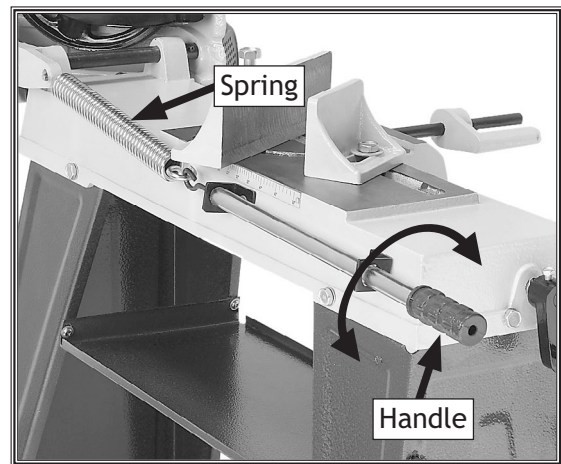


Figure 33. Feed rate spring and handle.

Blade Speed

The bandsaw is capable of operating at 78, 108, or 180 FPM. The speed can easily be adjusted by changing the V-belt placement. **Figure 34** shows an illustration of each pulley to belt combination, and the following list provides the blade speeds in feet per minute.

Belt Position	Blade Speed
A	78 FPM
B	108 FPM
C	180 FPM

To change the blade speeds, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Unthread the V-belt tension hex bolt to allow the motor to pivot (**Figure 35**).
3. Raise the motor to relieve the belt tension and position the belt in the desired pulley alignment.
4. Release the motor and let the motor weight tension the belt.
5. Position the V-belt tension hex bolt back against the frame of the bandsaw.

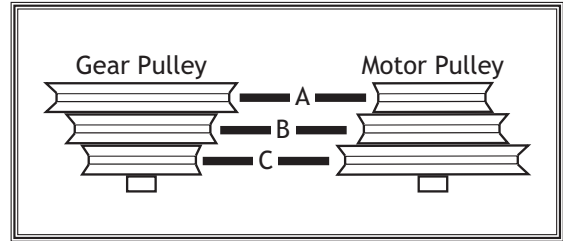


Figure 34. Pulley configurations.

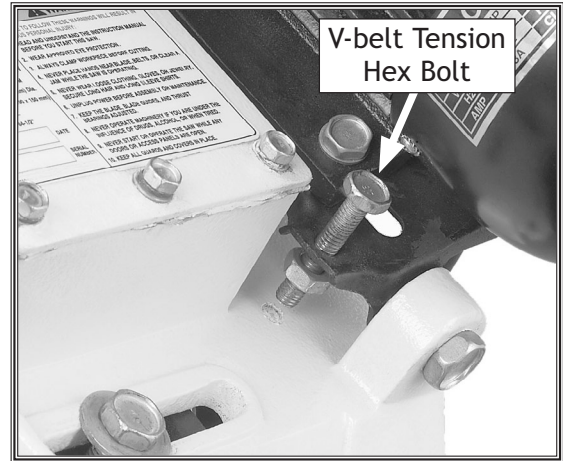


Figure 35. V-belt tension hex bolt.

Blade Terminology

Selecting the right blade for the cut requires a knowledge of various blade characteristics. Use the illustration in **Figure 36** and the following descriptions to better understand blade characteristics.

- A. **Kerf:** The width of the cut by the blade during cutting.
- B. **Tooth Set:** The amount each tooth is bent left or right from the blade.
- C. **Gauge:** The thickness of the blade.
- D. **Blade Width:** The widest point of the blade measured from the tip of the tooth to the back edge of the blade.
- E. **Tooth Rake:** The angle of the tooth from a line perpendicular to the length of the blade.
- F. **Gullet Depth:** The distance from the tooth tip to the bottom of the curved area (gullet).
- G. **Tooth Pitch:** The distance between tooth tips.
- H. **Blade Back:** The distance between the bottom of the gullet and the back edge of the blade.
- I. **TPI:** The number of teeth per inch measured from gullet to gullet.

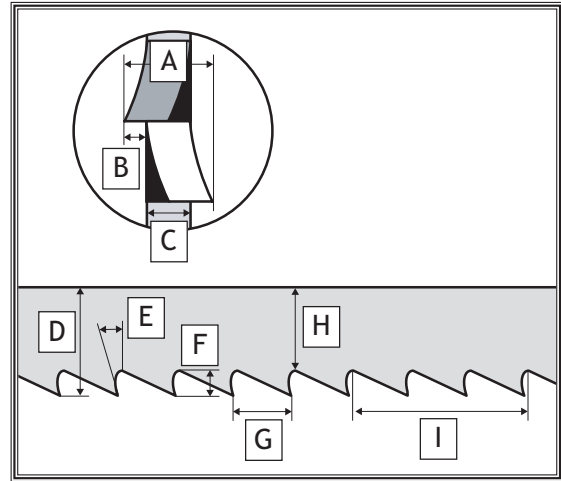


Figure 36. Bandsaw blade components.

Blade Selection

Blade Size

The Model W1715 accepts only 1/2" x 0.025 x 64 1/2" blades.

Tooth Pitch

Usually measured as TPI (Teeth Per Inch), tooth pitch determines the size/number of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster.

As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder metals and coarse pitched blades on softer metals. When selecting blades, refer to **Figure 37** for recommended blade tooth (TPI) and speed (FPM) based on the workpiece material.

Tooth Style

When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle—otherwise known as “Tooth Style.” Many blade manufacturers offer variations of the four basic styles shown in **Figure 38**.

Tooth Set

Three of the most common tooth sets are alternate, wavy, and raker (see **Figure 39**).

Material	TPI	FPM
Tool Steel Stainless Steel Bearing Bronze	24	78
Mild Steel Hard Brass Bronze	18	108
Soft Brass Aluminum Other Light Metals	14	180

Figure 37. Blade TPI and FPM chart.

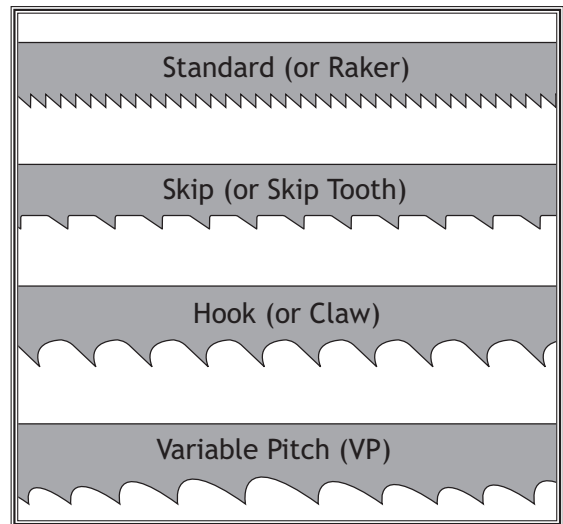


Figure 38. Bandsaw blade tooth styles.

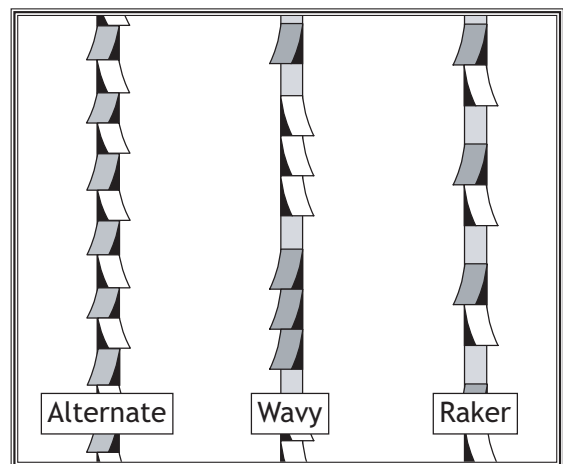


Figure 39. Bandsaw blade tooth sets.

Metal Chip Inspection Chart

The best method of evaluating the performance of your metal cutting operation is to inspect the chips that are formed from cutting. Refer to the chart below for chip inspection guidelines.





Chip Appearance	Chip Description	Chip Color	Blade Speed	Feed Pressure	Additional Actions
	Thin & Curled	Silver	<i>Good</i>	<i>Good</i>	
	Hard, Thick & Short	Brown or Blue	Decrease	Decrease	Lubricate with a small amount of oil
	Hard, Strong & Thick	Brown or Blue	Decrease	Decrease	Lubricate with a small amount of oil
	Hard, Strong & Thick	Silver or Light Brown	<i>Good</i>	Decrease Slightly	Check Blade Pitch
	Hard & Thin	Silver	Increase	Decrease	Check Blade Pitch
	Straight & Thin	Silver	<i>Good</i>	Increase	
	Powdery	Silver	Decrease	Increase	
	Curled Tight & Thin	Silver	<i>Good</i>	Decrease	Check Blade Pitch

Figure 40. Metal chip inspection chart.

ACCESSORIES

Metal Cutting Bandsaw Accessories

The following Metal Cutting Bandsaw accessories may be available through your local Woodstock International Inc. Dealer. If you do not have a dealer in your area, these products are also available through online dealers. Please call or e-mail Woodstock International Inc. Customer Service to get a current listing of dealers at: 1-800-840-8420 or at sales@woodstockint.com.

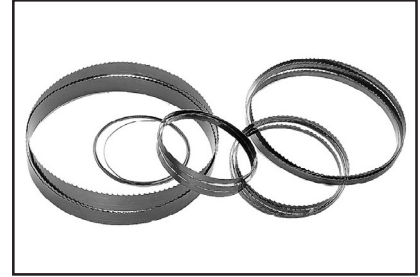
Metal Cutting Bandsaw Blades

D3320—64-1/2" x 1/2" x 0.025" 10 TPI

D3321—64-1/2" x 1/2" x 0.025" 14 TPI

D3322—64-1/2" x 1/2" x 0.025" 18 TPI

D3323—64-1/2" x 1/2" x 0.025" 24 TPI



Model D2273 Single Roller Stand

Large diameter ball bearing roller stand features smooth operation for a variety of processing and work support applications. Heavy pedestal base is stable and secure.

Model D2274 5 Roller Stand

For greater work stability and support, this 5 roller stand features large diameter, ball bearing rollers mounted on a sturdy adjustable pedestal base.



Shop Fox Safety Glasses

Exceeding ANSI Z87.1-1989 standards for impact resistance, these Safety Glasses offer outstanding eye protection and stylish good looks. Wrap-around side shields provide additional protection and a wide field of view. Model D2676 features easily adjustable ear pieces for length and comfort.



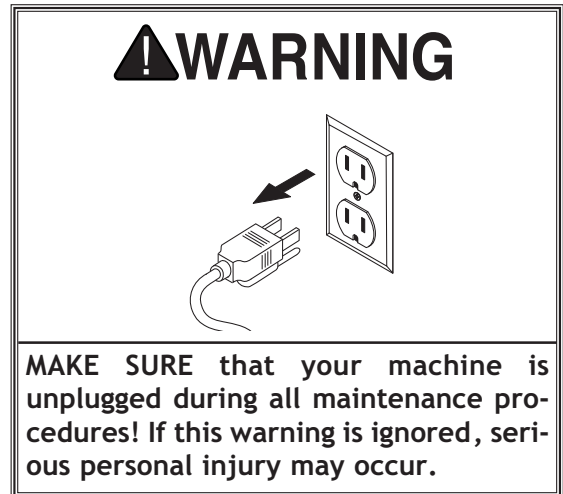
MAINTENANCE

General

Regular periodic maintenance on your machine will ensure its optimum performance. Make a habit of inspecting your machine each time you use it.

Check for the following conditions and repair or replace when necessary:

- Loose mounting bolts.
- Worn switch.
- Worn or damaged cords and plugs.
- Damaged bandsaw blade.
- Any other condition that could hamper the safe operation of this machine.



Cleaning

Frequently use a brush and a shop vacuum to remove chips and other debris from the machine. Keep the non-painted surfaces rust-free with regular applications of an anti-rust protectorate.

Periodically, remove the blade and thoroughly clean all metal chips or built-up grease from the wheel surfaces and blade housing.

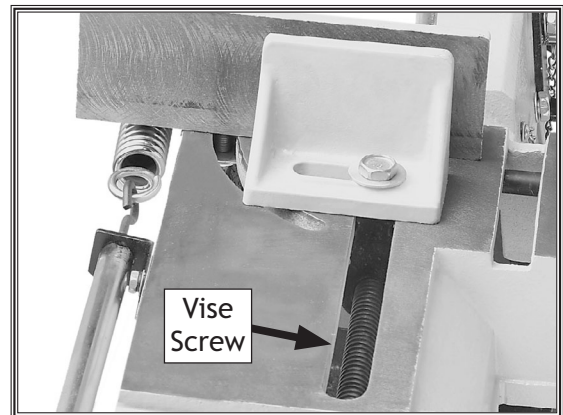


Figure 41. Vise screw.

Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vise screw shown in **Figure 41** with multi-purpose gear grease.

Remove the cover on the gearbox shown in **Figure 42** and coat the gears with multi-purpose gear grease.

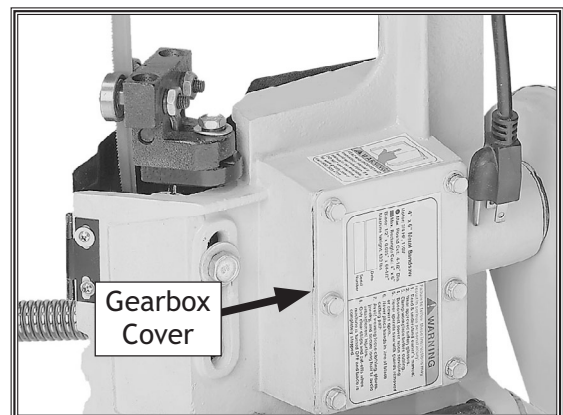


Figure 42. Gearbox cover.

MAINTENANCE

SERVICE

Blade Change

Blades should be changed when they become dull, damaged, or when your operation requires a different blade.

To change the blade on the bandsaw, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Raise the head of the bandsaw to the vertical position, use the head locking pin to hold it in place, then remove the wheel access cover.
3. Loosen the tension knob and slip the blade off of the wheels.
4. Install the new blade through both blade guide bearings, as shown in **Figure 43**, and around the bottom wheel.
5. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

Note: *It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 44**, after mounting to the bandsaw. Some blades will have a directional arrow as a guide.*

6. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels (see **Figure 45**).
7. Tighten the tension knob so the blade will not slip on the wheels upon start up.
8. Connect the bandsaw to the power source.
9. Briefly turn the bandsaw **ON** then **OFF** to position the blade and resume the previous tracking.

–If the tracking needs to be adjusted, see **Blade Tracking** in the next section.

–If the tracking is fine, proceed to **Blade Tension** on **Page 32**.

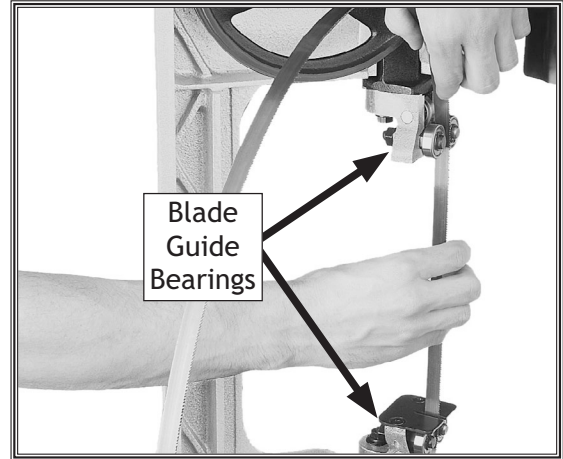


Figure 43. Installing the blade.

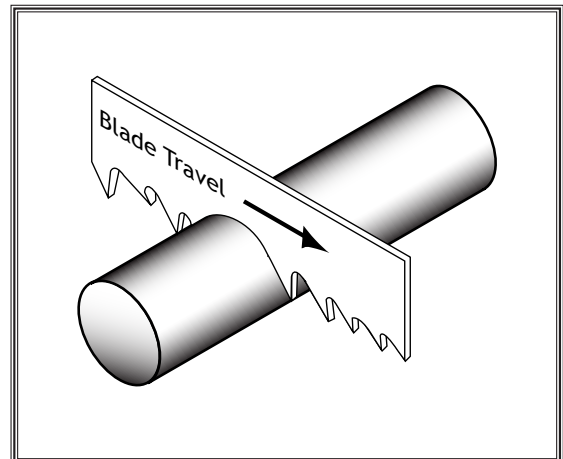


Figure 44. Correct blade travel.

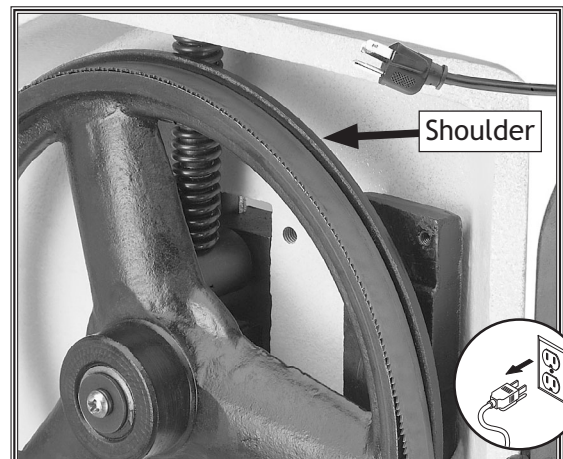


Figure 45. Blade installed on the top wheel.

Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

Tools Needed	Qty
Wrench or Socket 14mm.....	1

To adjust the blade tracking on the bandsaw, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Position the bandsaw in the vertical position.
3. Open the wheel access cover.
4. Loosen, but do not remove the lower hex bolt in the blade wheel tilting mechanism shown in **Figure 46**.
5. Use the blade tension knob to release the blade tension (see **Figure 47**).
6. Adjust the tracking hex bolt, as shown in **Figure 47**, then tighten the lower hex bolt loosened in **Step 4**.
 - Tightening the tracking hex bolt will move the blade closer to the shoulder of the wheel.
 - Loosening the tracking hex bolt will move the blade away from the shoulder.
7. Tension the blade.
8. Reconnect the power and turn **ON** the bandsaw.
 - If the blade tracks along the shoulder of the wheel (without rubbing), the blade is tracking properly and this adjustment is completed.
 - If the blade walks away from the shoulder of the wheel or hits the shoulder, turn the bandsaw **OFF**, disconnect it from power, then repeat **Steps 4-8**.
9. Turn the bandsaw **OFF**, disconnect it from power, then replace the blade guard and wheel access cover.

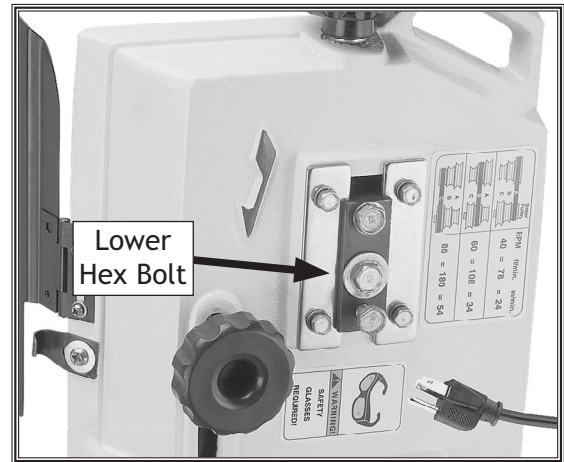


Figure 46. Blade wheel tilting lower hex bolt.

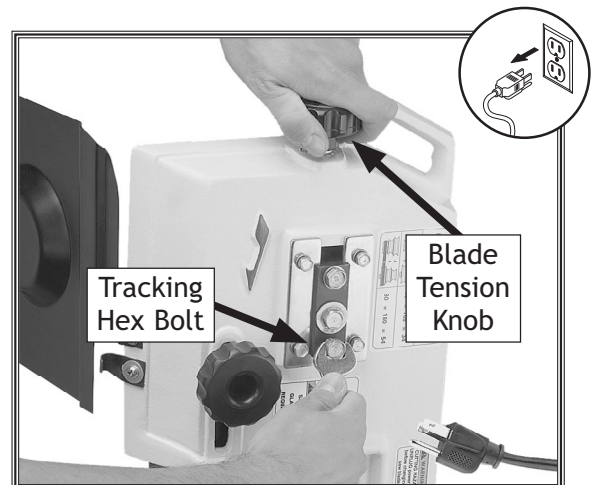


Figure 47. Adjusting the tracking hex bolt.

Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting times.

Two major signs that you do not have the correct blade tension are: 1) The blade stalls in the cut and is slipping on the wheels, and 2) the blade frequently breaks from being too loose.

To tension the blade on the bandsaw, do these steps:

1. Make sure the blade is tracking properly.
2. DISCONNECT BANDSAW FROM POWER!
3. Loosen and slide the blade guides as far apart as they will go then tighten them down again.
4. Turn the blade tension knob in **Figure 48** clockwise to tighten the blade as tight as you can.
5. Using moderate finger pressure, push against the side of the blade. The blade should not move more than 0.004".

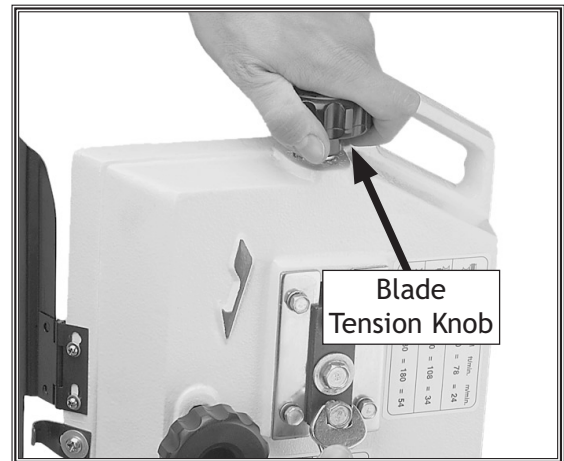


Figure 48. Blade tension knob.

Squaring Blade

It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

To square the blade to the bed of the table, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Separate the blade guides as far as possible, the lower the head of the bandsaw all the way until it contacts the horizontal stop.
3. Place a square on the table bed and against the edge of the blade (**Figure 49**), and check different points along the length of the table between the blade guides.
4. Loosen the hex bolt shown in **Figure 49**, and rotate the seat until the blade is vertical to the bed, then re-tighten the hex bolt.

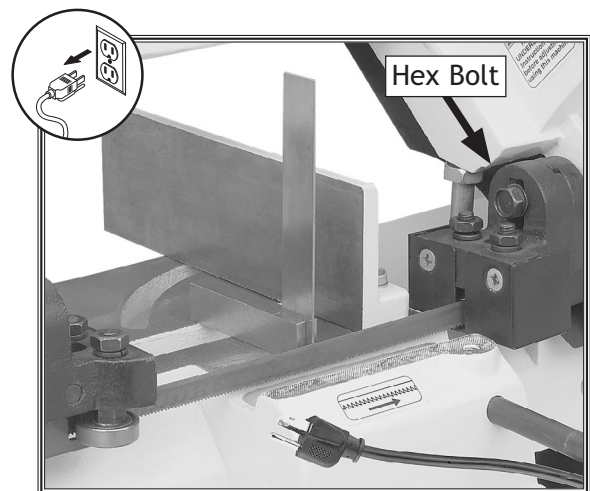


Figure 49. Squaring the blade.

Blade Guide Bearings

The blade guide bearings must be properly adjusted to make square cuts. One bearing on each assembly has an eccentric bushing that allows it to be adjusted so the blade is square to the vise. The bearings are secured in place by a hex nut and lock washer, as shown in **Figure 50**.

Before adjusting the blade guide bearings, make sure that you have squared the blade to the table as discussed in the previous section.

To adjust the blade guide bearings, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Position the vise to 90°, then lock it in place.
3. Put a machinist's square against the face of the vise and move it over to the blade.
 - The square should evenly touch both the face of the vise and the blade. If it does, skip ahead to **Step 6**.
 - If the square does not evenly touch the blade, but it does evenly touch the vise, continue with the next step.
4. Loosen the hex nuts that secure the eccentric bushings attached to the guide bearings.
5. Adjust the bearings as necessary to force the blade to be 90° to the vise, then re-tighten the hex nuts.
6. If any of the bearings are not touching the blade evenly, loosen the hex nuts and adjust them so the contact surface of the bearings touch the blade evenly.

Note: *Since the bearings twist the blade into position, it is acceptable if there is 0.001"-0.002" gap between the blade and the front or back of the bearing. Just make sure not to squeeze the blade too tightly with the bearings. After the guide bearings are set, you should be able to rotate the guide bearings (although they will be stiff) with your fingers.*

7. Adjust the backing bearing in the same manner, but leave a gap between 0.002-0.003" from the back of the blade.

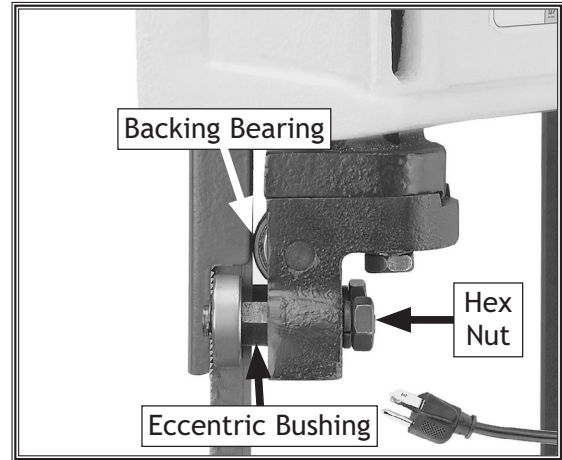


Figure 50. Blade guide adjustment controls.

Changing V-Belt

Check the V-belt periodically for signs of glazing, cracking, or fraying. If any of these conditions are present, change the V-belt.

To change the V-belt, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the V-belt tension hex bolt on the motor mounting plate to allow the motor to pivot (see **Figure 51**).
3. Open the pulley cover door to access the V-belt, as shown in **Figure 52**.
4. Pivot the motor towards the gear box to release belt tension and remove the V-belt.
5. Replace the V-belt and let the weight of the motor provide the tension.
6. Secure the V-belt tension bolt.



Figure 51. V-belt tension hex bolt.



Figure 52. Installing the V-belt.

Electrical Safety Instructions

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this diagram carefully. If you notice differences between your machine and these wiring diagrams, call Woodstock International Technical Support at (360) 734-3482.

WARNING

1. **SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!
2. **QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.
3. **WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.
4. **WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.
5. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.
6. **MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.
7. **CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on these components.
8. **ELECTRICAL REQUIREMENTS.** You **MUST** follow the electrical requirements at the beginning of this manual when connecting your machine to a power source.
9. **EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (360) 734-3482.

NOTICE	WIRING DIAGRAM COLOR KEY			
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.shopfox.biz .	BLACK	BLUE	YELLOW	LIGHT BLUE
	WHITE	BROWN	YELLOW GREEN	BLUE WHITE
	GREEN	GRAY	PURPLE	TUR-QUOISE
	RED	ORANGE	PINK	

Electrical Components

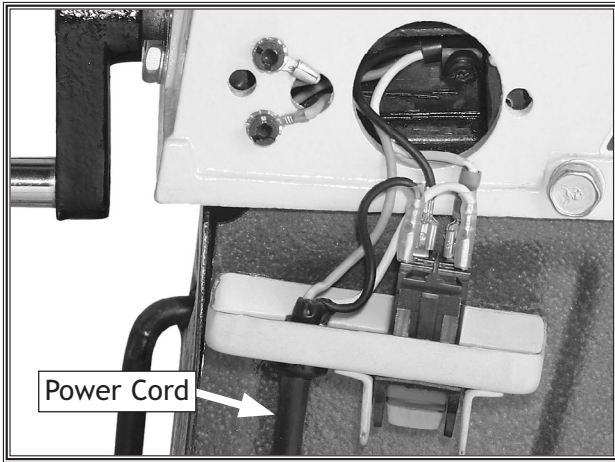
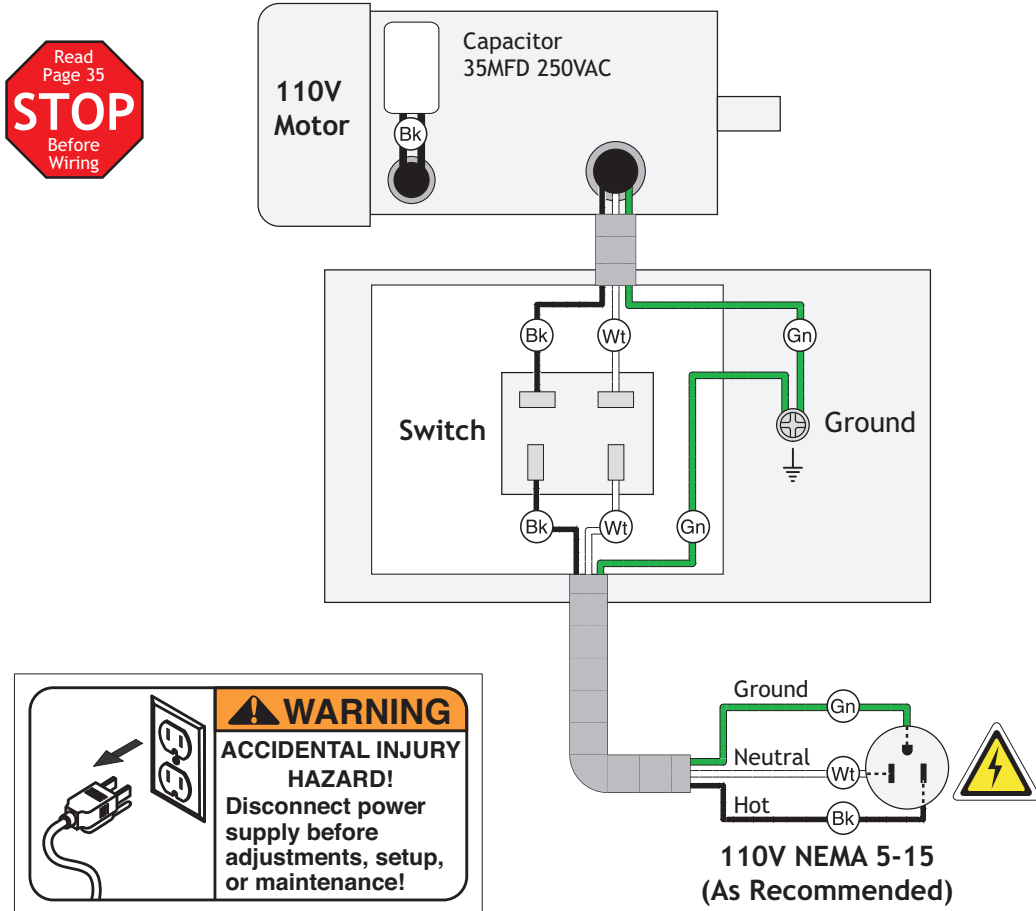


Figure 53. ON/OFF switch wiring.



Figure 54. Start capacitor.

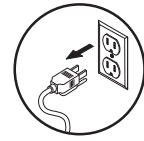
Wiring Diagram



SERVICE

Troubleshooting

This section covers the most common problems and corrections with this type of machine. **WARNING! DO NOT** make any adjustments until power is disconnected and moving parts have come to a complete stop!



PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Plug/receptacle is at fault or wired incorrectly. 2. Start capacitor is at fault. 3. Motor connection wired incorrectly. 4. Power supply is at fault/switched OFF. 5. ON/OFF switch is at fault. 6. Wiring is open/has high resistance. 7. Motor is at fault. 	<ol style="list-style-type: none"> 1. Test for good contact or correct the wiring. 2. Test/replace if faulty. 3. Correct motor wiring connections. 4. Make sure all hot lines/grounds are operational and have correct voltage on all legs. 5. Replace faulty ON button or ON/OFF switch. 6. Troubleshoot wires for internal/external breaks; check for disconnected/corroded connections; repair/replace wiring. 7. Test/repair/replace.
Machine stalls or is under-powered.	<ol style="list-style-type: none"> 1. Wrong blade for the workpiece material (metal). 2. Feed rate too fast for task. 3. V-belt slipping. 4. Blade is slipping on wheels. 5. Pulley/sprocket slipping on shaft. 6. Motor bearings are at fault. 7. Motor is at fault. 	<ol style="list-style-type: none"> 1. Use blade with correct properties for your type of cutting. 2. Decrease feed rate. 3. Replace bad V-belt and re-tension. 4. Adjust blade tracking and tension. 5. Replace loose pulley/shaft. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. V-belt is slapping belt cover. 2. V-belt worn or loose. 3. Pulley is loose. 	<ol style="list-style-type: none"> 1. Inspect belt cover for proper installation. 2. Inspect/replace belt with a new one. 3. Realign/replace shaft, pulley, setscrew, and key as required.
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> 1. Excessive feed rate. 2. The blade TPI is too great, or the material is too coarse. 	<ol style="list-style-type: none"> 1. Refer to Feed Rate on Page 23, or Blade Speed on Page 24 and adjust as required. 2. Refer to Blade Selection on Page 26 and adjust as required.

PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Blades break often.	<ol style="list-style-type: none"> 1. The workpiece is loose in the vise. 2. The feed or cut speed is wrong. 3. The blade TPI is too great, or the material is too coarse. 4. The blade is rubbing on the wheel flange. 5. The bandsaw is being started with the blade resting on the workpiece. 6. The guide bearings are misaligned, or the blade is rubbing on the wheel flange. 7. The blade is too thick, or the blades are of low quality. 	<ol style="list-style-type: none"> 1. Clamp the workpiece tighter, or use a jig to hold the workpiece. 2. Refer to Feed Rate on Page 23, or Blade Speed on Page 24 and adjust as required. 3. Refer to Blade Selection on Page 26 and adjust as required. 4. Refer to Blade Tracking on Page 31, and adjust as required. 5. Start bandsaw and then slowly lower the headstock by setting the feed rate. 6. Refer to Blade Tracking on Page 31, or Blade Guides on Page 23, and adjust as required. 7. Use a higher quality blade.
Blade dulls prematurely.	<ol style="list-style-type: none"> 1. The cutting speed is too fast. 2. The blade TPI is too coarse. 3. The blade feed pressure is too light. 4. The workpiece has hard spots, welds, or scale is on the material. 5. The blade is twisted. 6. The blade is slipping on the wheels. 	<ol style="list-style-type: none"> 1. Refer to Blade Speed on Page 24 and adjust as required. 2. Refer to Blade Selection on Page 26 and adjust as required. 3. Refer to Feed Rate on Page 23, and adjust as required. 4. Increase the feed pressure, and reduce the cutting speed. 5. Replace the blade. 6. Refer to Blade Tension on Page 32, and adjust as required.
Blade wears on one side.	<ol style="list-style-type: none"> 1. The blade guides are worn or mis-adjusted. 2. The blade guide slide bracket is loose. 3. The wheels are out of alignment. 	<ol style="list-style-type: none"> 1. Refer to Blade Guides on Page 23 and replace or adjust. 2. Tighten the blade guide bracket. 3. Refer to Blade Tracking on Page 31, and adjust as required.
Teeth are ripping from the blade.	<ol style="list-style-type: none"> 1. The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. 2. The workpiece is vibrating in the vise. 3. The blade gullets are loading up with chips. 	<ol style="list-style-type: none"> 1. Refer to Blade Selection on Page 26 and decrease the feed pressure. Refer to Feed Rate on Page 23, and adjust as required. 2. Re-clamp the workpiece in the vise, and use a jig if required. 3. Use a coarser-tooth blade.
The cuts are crooked.	<ol style="list-style-type: none"> 1. The feed pressure is too high. 2. The guide bearings are out of adjustment, or too far away from the workpiece. 3. The blade tension is low. 4. The blade is dull. 5. The blade speed is wrong. 	<ol style="list-style-type: none"> 1. Refer to Feed Rate on Page 23, and adjust as required. 2. Refer to Blade Guides on Page 23 and replace or adjust. 3. Refer to Blade Tension on Page 32, and adjust as required. 4. Refer to Blade Change on Page 30 and replace the blade. 5. Refer to Blade Speed on Page 24 and adjust as required.

Parts List

REF	PART #	DESCRIPTION
1	XPB02M	HEX BOLT M6-1 X 12
2	XPNO1M	HEX NUT M6-1
3	XPW03M	FLAT WASHER 6MM
4	X1715004	STAND LEG (RIGHT)
5	X1715005	WHEEL ASSY
6	X1715006	COTTER PIN
7	XPS14M	PHLP HD SCR M6-1 X 12
8	X1715008	LOCKING LEVER
9	XPW03M	FLAT WASHER 6MM
10	XPFH19M	FLAT HD SCR M4-.7 X 10
11	XPB20M	HEX BOLT M8-1.5 X 35
12	XPNO3M	HEX NUT M8-1.25
13	X1715013	STAND LEG (LEFT)
14	X1715014	TRANSPORT HANDLE
15	X1715015	ADJUSTING ROD
16	X1715016	MOTOR CORD
17	X1715017	PIVOTING ROD
18	X1715018	SUPPORT PLATE
19	X1715019	WORK STOP
20	XPSS04M	SET SCREW M6-1 X 12
21	X1715021	STOCK STOP ROD
22	X1715022	WIRE RELIEF RETAINER
23	X1715023	SWITCH
24	XPNO6M	HEX NUT M5-.8
26	X1715026	SWITCH PANEL
27	X1715027	ADJUSTING ROD SUPPORT
28	X1715028	HAND WHEEL
30	XPR47M	EXT RETAINING RING 13MM
32	X1715032	LEADSCREW M16-4 X 358
33	X1715033	WISE NUT M6-4
34	X1715034	FRONT VISE JAW
35	X1715035	MOTOR 3/4HP 110V 1PH
35-1	X1715035-1	MOTOR FAN COVER
35-2	X1715035-2	MOTOR FAN
35-3	X1715035-3	CAPACITOR COVER
35-4	X1715035-4	CAPACITOR 35M 250V
35-5	X1715035-5	JUNCTION BOX
36	XPB01M	HEX BOLT M10-1.5 X 30
37	X1715037	BED
39	X1715039	SCALE
40	X1715040	ELECTRIC CORD COVER
43	X1715043	GASKET
44	X1715044	POWER CORD
45	X1715045	NUT PLATE
46	X1715046	SPRING ADJUST SCREW M5-.8 X 40

REF	PART #	DESCRIPTION
47	X1715047	EXTENSION SPRING 22 x 4.5 x 215
48	XPS38M	PHLP HD SCR M4-.7 X 10
49	X1715049	REAR VISE JAW
50	XPSS14M	SET SCREW M8-1.25 X 12
51	XPW01M	FLAT WASHER 8MM
52	XPB07M	HEX BOLT M8-1.25 X 25
53	XPB43M	HEX BOLT M12-1.75 X 75
54	X1715054	PIVOT
55	X1715055	TABLE
56	X1715056	TABLE BRACKET
56-1	XPWF06M	FENDER WASHER 6MM
56-2	XPNO1M	HEX NUT M6-1
57	X1715057	ADJUSTABLE BRACKET (TOP)
58	X1715058	KNOB BOLT M10-1.5 X 25
58A	XPS09M	PHLP HD SCR M5-.8 X 10
58A-1	XPW02M	FLAT WASHER 5MM
59	X1715059	BLADE BACK SAFETY COVER
59A	X1715059A	PLATE
59A-1	X1715059A-1	KNOB M6-1 X 8
60	XPR39M	EXT RETAINING RING 8MM
61	XP629ZZ	BALL BEARING 629ZZ
62	X1715062	GUIDE PIVOT
63	X1715063	BEARING SHAFT PIN 8 X 40MM
64	X1715064	BLADE ADJUSTABLE SEAT
65	X1715065	ADJUSTABLE BRACKET
66	X1715066	GUIDE BEARING LOCK
67	XPLW04M	LOCK WASHER 8MM
68	XPFH02M	FLAT HD SCR M6-1 X 12
69	X1715069	BLADE GUARD
70	XPNO3M	HEX NUT M8-1.25
71	X1715071	BLADE WHEEL (FRONT)
72	X1715072	BLADE WHEEL BEARING COVER
73	XPK12M	KEY 5 X 5 X 30
75	XPS14M	PHLP HD SCR M6-1 X 12
76	X1715076	SWITCH CUT OFF TIP
77	X1715077	BLADE WHEEL (REAR)
79	X1715079	BLADE TENSION KNOB
80	X1715080	COMPRESSION SPRING 14.5 X 2 X 76
81	X1715081	BODY FRAME
83	XPB07M	HEX BOLT M8-1.25 X 25
84	X1715084	MOTOR MOUNT PLATE
85	XPW04M	FLAT WASHER 10MM
86	X1715086	MOTOR PULLEY
87	XP620ZZ	BALL BEARING 620ZZ
88	X1715088	BEARING BUSHING

Parts List

REF	PART #	DESCRIPTION
89	X1715089	OIL SEAL
90	X1715090	TRANSMISSION WHEEL SHAFT
91	X1715091	TRANSMISSION GEAR
92	X1715092	GEAR BOX GASKET
93	X1715093	GEAR BOX COVER
94	X1715094	WORM GEAR
96	X1715096	BEARING BUSHING
98	XPB166M	HEX BOLT M8-1.25 X 50
99	X1715099	BUSHING
101	X1715101	WORM GEAR PULLEY
103	X1715103	BLADE TENSION PLATE
104	XPB20M	HEX BOLT M8-1.25 X 35
106	X1715106	SLIDING PLATE DRAW BLOCK
107	X1715107	BLADE WHEEL SHAFT
108	X1715108	SHAFT BLOCK
109	X1715109	BLADE TENSION SLIDING GUIDES
110	X1715110	MOTOR PULLEY COVER
112	X1715112	V-BELT 3L215
113	X1715113	BLADE 1/2 X .025 X 64-1/2
114	XPW01M	FLAT WASHER 8MM
117	XPW03M	FLAT WASHER 6MM
118	XPR05M	EXT RETAINING RING 15MM
120	XP620ZZ	BALL BEARING 620ZZ

REF	PART #	DESCRIPTION
122	XPN09M	HEX NUT M12-1.75
126A	XP620ZZ	BALL BEARING 620ZZ
126A-1	XPR21M	INT RETAINING RING 35MM
132	X1715132	BLADE SAFE GUARD
156	XPS22M	PHLP HD SCREW M5-.8 X 25
157	XPLW01M	LOCK WASHER 5MM
170	X1715170	TOOL PLATE
171	XPB10M	HEX BOLT M6-1 X 25
172	XPN01M	HEX NUT M6-1
173	XPW03M	FLAT WASHER 6MM
174	X1715174	WHEEL STAND
175	X1715175	COTTER PIN
176	X1715176	AXLE
177	X1715177	CORNER BRACKET
178	X1715178	MACHINE ID LABEL
179	XLABEL-12	READ MANUAL LABEL
180	X1715180	SAFETY GLASSES LABEL
181	XLABEL-04	ELECTRICITY LABEL
182	X1715182	UNPLUG MACHINE LABEL
183	X1715183	RPM LABEL
184	X1715184	BLADE TRAVEL LABEL
185	X1715185	BLADE SAFETY LABEL
186	X1715186	TIPPING HAZARD LABEL

WARNING

Safety labels warn about machine hazards and how to prevent machine damage or injury. The owner of this machine **MUST** maintain the original location and readability of all labels on this machine. If any label is removed or becomes unreadable, **REPLACE** that label before allowing the machine to enter service again. Contact Woodstock International, Inc. at (360) 734-3482 or www.shopfoxtools.com to order new labels.



Warranty Registration

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 Model # _____ Serial # _____ Dealer Name _____ Purchase Date _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

- How did you learn about us?

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Local Store
<input type="checkbox"/> Mail Order Catalog	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
- How long have you been a woodworker/metalworker?

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
------------------------------------	------------------------------------	-------------------------------------	------------------------------------
- How many of your machines or tools are Shop Fox?

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
------------------------------	------------------------------	------------------------------	------------------------------
- Do you think your machine represents a good value? Yes No
- Would you recommend Shop Fox products to a friend? Yes No
- What is your age group?

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
- What is your annual household income?

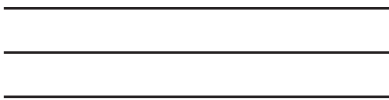
<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
- Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

9. Comments: _____

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WARRANTY

Woodstock International, Inc. warrants all Shop Fox machinery to be free of defects from workmanship and materials for a period of two years from the date of original purchase by the original owner. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, lack of maintenance, or reimbursement of third party expenses incurred.

Woodstock International, Inc. will repair or replace, at its expense and at its option, the Shop Fox machine or machine part, which in normal use has proven to be defective, provided that the original owner returns the product prepaid to a Shop Fox factory service center with proof of their purchase of the product within two years, and provides Woodstock International, Inc. reasonable opportunity to verify the alleged defect through inspection. If it is determined there is no defect, or that the defect resulted from causes not within the scope of Woodstock International Inc.'s warranty, then the original owner must bear the cost of storing and returning the product.

This is Woodstock International, Inc.'s sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant that Shop Fox machinery complies with the provisions of any law or acts. In no event shall Woodstock International, Inc.'s liability under this warranty exceed the purchase price paid for the product, and any legal actions brought against Woodstock International, Inc. shall be tried in the State of Washington, County of Whatcom. We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special or consequential damages arising from the use of our products.

Every effort has been made to ensure that all Shop Fox machinery meets high quality and durability standards. We reserve the right to change specifications at any time because of our commitment to continuously improve the quality of our products.



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